

Quality Control

30 02/17/04/20

(32) _____ 0-17/04/20

Work Order ID 159722

Thursday, April 27, 2017 11:08:41 AM

159722

Page 2

Item ID: D3413-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: O-Ring
 Start Date: 4/19/2017 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 4/25/2017 Req'd Qty: 30.00 ***30*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.72				30			DAS 38 9-88 APR 27 2017
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 17136657 Memo START TIME: 11:05 OVEN TEMPERATURE: 900° FINISH TIME: 11:35	0.00 0.74				15	15	1705-2	DAS 38 9-88 MAY 02 2017
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.72				15			DAS 38 9-88 MAY 02 2017

Work Order ID 159722

Thursday, April 27, 2017 11:08:42 AM

159722

Page 3

Item ID: D3413-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: O-Ring
 Start Date: 4/19/2017 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 4/25/2017 Req'd Qty: 30.00 ***30*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>51530</u>	0.00							
170									
Packaging	Memo	3.60							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.36							
Quality Control									

MAY 04 2017

17/5/8 JF

DAS
21
9-89

MAY 04 2017

Picklist Print

Thursday, April 27, 2017 11:08:41 AM

Page 1

Work Order ID: 159722

159722

Parent Item: D3413-1

D3413-1

Parent Item Name: O-Ring

Start Date: 4/19/2017

Required Date: 4/25/2017

Start Qty: 30.00

Required Qty: 30.00

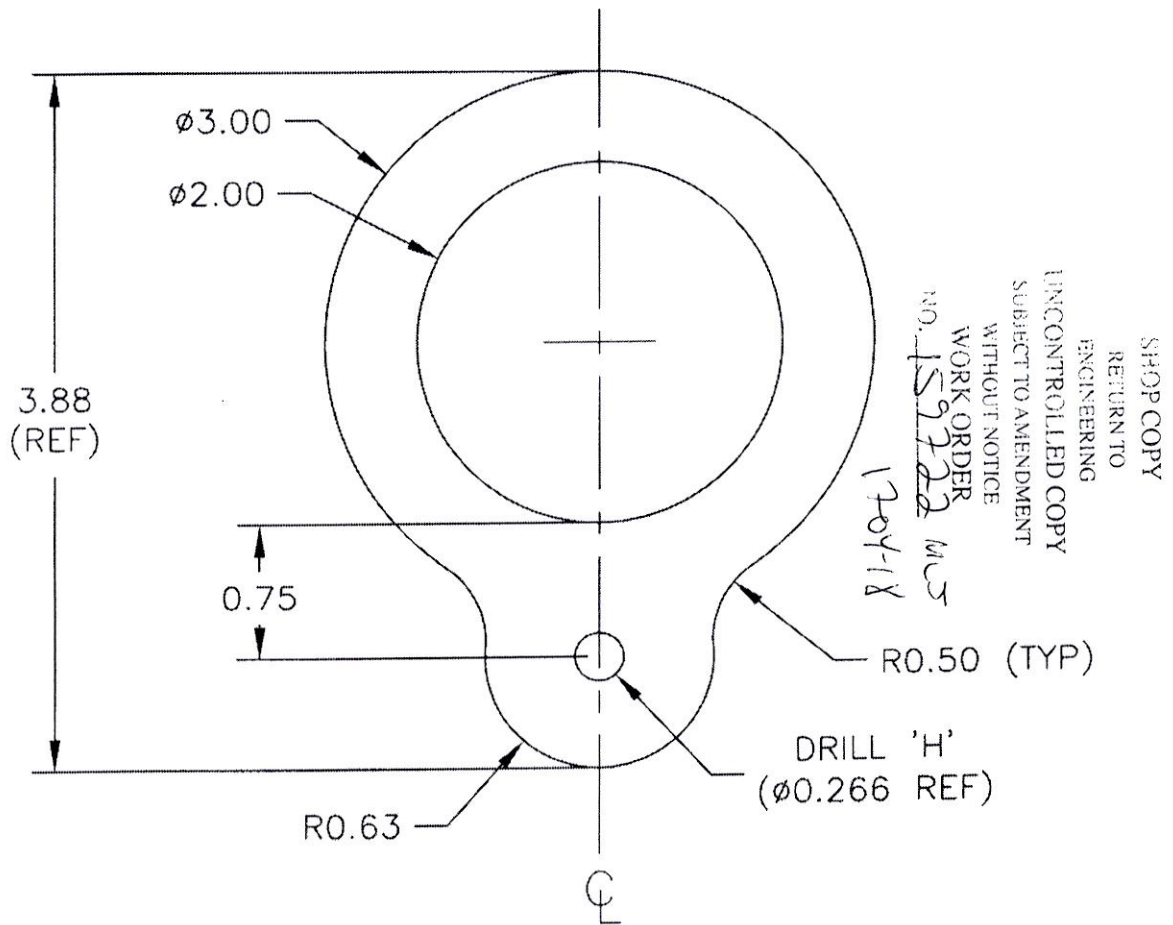
Comments: IPP Rev:A05.09.13New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	22.7000	0.25	7.894737			
M304B0 250X4 000									**	<u>12-17/01/27</u>			
304 BAR .250 x 4.00													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT009		22.7					
						M135860		10.7		<u>10.7</u>			
						M137362		12					



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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